

Work Order ID 63843

Tuesday, November 16, 2010 1:18:57 PM



Page 1

Item ID: D2221

Accept



Setup Start



Revision ID:

Item Name: 350 Basket Base

Stop



Start Date: 11/16/2010 Start Qty: 1.00



Cust Item ID:

Required Date: 11/22/2010 Req'd Qty: 1.00



Customer:

Reference:

Approvals:

Process Plan:

[Signature]

Date: 10-11-14

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D2221	Rev H

100		0.00
-----	--	------



Large Fab

Large Fab

Memo

0.00

Large Fab

1- assemble all ribs and both D2581 in DT9444 jig, weld as per dwg D2221
2- remove basket from jig and weld D3442-1 shims and D2232-3 hinges as per dwg D2221
3- tack weld mesh on basket as per dwg D2221
A/R ER316 S.S. Rod Batch: *M114649*

PLEASE NOTE

IF MAKING -041A OR -043A :
DRILL HOLES FOR GAS SPRING
IN D3825-041 AS PER
DSI 9473

[Signature] 10/11/24 (1x)

110	QC9- Inspect visual per QSI004- Fusion Welds	0.00
-----	--	------



QC

Memo

0.00

Quality Control

[Signature] 10-11-24

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

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Required Date: 11/22/2010 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

120

QC6- Inspect dimensions to drawing

0.00



QC

Memo

0.00

Quality Control

8 10/11/24



125

Pressure Wash per QSI005 4.3

0.00



HandFinish

Memo

0.00

Hand Finishing

1 BR 10-11-25

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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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150

Identify as per dwg & Stock Location

0.00



Packaging

Memo

w/o 63780

0.00

Packaging

E50/11/25 (1)

160

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10-11-26
MF
10-11-25

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Page 1

Required Date: 11/22/2010

Required Qty: 1.00

Comments:

IPP Rev:J	05.09.02	Added D3442-1	OKJ/JLM	
IPP Rev:K	08-08-29	revG as per dwg	DD	verified by:EC
IPP Rev:L	08-09-24	plug holes prior to powder coat	DD	verified by:EC
IPP Rev:M	08-12-02	revH as per dwg	DD	verified by:EC
	10.06.29	added pressure wash	DD	verf:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2221-1  Rib		Manufactured	No			100	Each	6.0000	1	1			
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				WA		6							
				61424		1							
				62519		5							
D2221-5  Rib		Manufactured	No			100	Each	10.0000	2	2			
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				WA		10							
				61753		2							
				62996		8							
D2221-7  Rib		Manufactured	No			100	Each	5.0000	1	1			
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				WA		5							
				61754		1							
				62997		4							

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Picklist Print

Tuesday, November 16, 2010 1:19:02 PM

Page 2 *14*

Work Order ID: 63843

Parent Item: D2221

Parent Item Name: 350 Basket Base

Start Date: 11/16/2010

Required Date: 11/22/2010

Start Qty: 1.00

Required Qty: 1.00

✓ D2232-3
Basket Hinge

Manufactured No

100 Each

4.0000

2

2



10/11/18

Location

Loc Qty

Loc Code

WA

4

63003

4

2x

✓ D2235-1
Basket Rib

Manufactured No

100 Each

10.0000

2

2



10/11/18

Location

Loc Qty

Loc Code

WA

10

62254

4

2x

62988

6

✓ D2581
Mounting Bracket

Manufactured No

100 Each

41.0000

2

2



10/11/18

Location

Loc Qty

Loc Code

WA

41

61953

20

63493

21

2x

✓ D3442-1
Shim

Manufactured No

100 Each

18.0000

2

2



10/11/18

Location

Loc Qty

Loc Code

WA

18

61181

6

2x

63002

12

W/O:		WORK ORDER CHANGES					
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Page 3

Work Order ID: 63843

Parent Item: D2221



Parent Item Name: 350 Basket Base

Start Date: 11/16/2010

Required Date: 11/22/2010

Start Qty: 1.00

Required Qty: 1.00

✓ D3825-041	Manufactured	No	100	Each	4.0000	2	2		<i>LS</i> 10/11/18
									
Rib Assembly (Basket End)									

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Shop Packet Print

Page 3

W/O:		WORK ORDER CHANGES					
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Picklist Print

Tuesday, November 16, 2010 1:19:02 PM

Page 4

14

Work Order ID: 63843



Parent Item: D2221



Parent Item Name: 350 Basket Base

Start Date: 11/16/2010

Required Date: 11/22/2010

Start Qty: 1.00

Required Qty: 1.00

D3833-1

Manufactured No

100

Each

14.0000

2



10/11/18

Mesh (Base End Face)

Location

Loc Qty

Loc Code

WA

14

62383

4

63255

10

OK

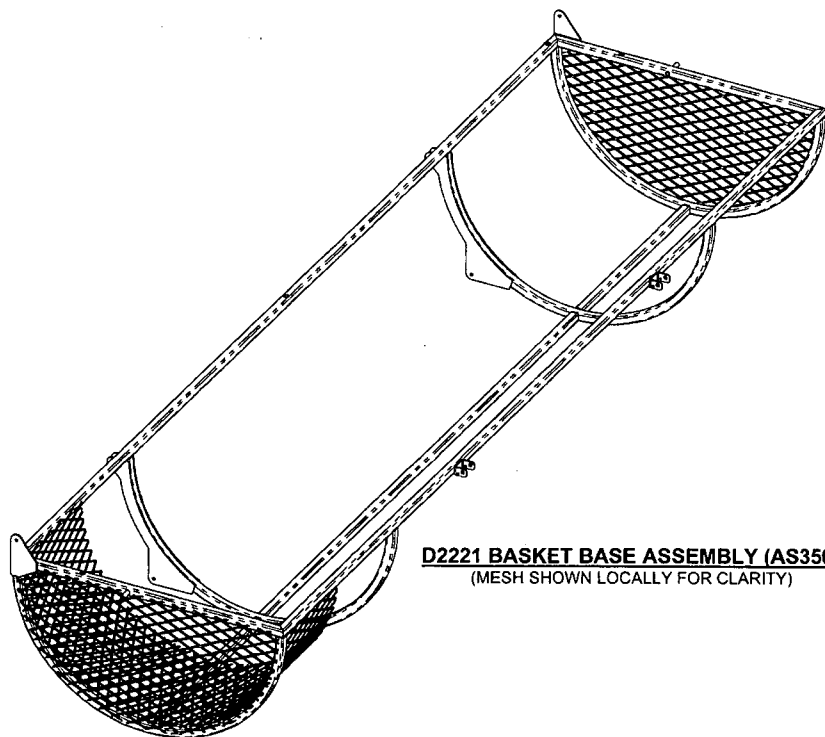
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D2221 BASKET BASE ASSEMBLY (AS350)
(MESH SHOWN LOCALLY FOR CLARITY)

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 63843

PS10-11-14

ITEM	QTY	P/N	DESCRIPTION
1	X	D2221	BASKET BASE ASSEMBLY (AS350)
2	1	D2221-1	RIB
3	2	D222 5	RIB
4	1	D2221-7	RIB
5	2	D2232-3	BASKET HINGE
6	2	D2235-1	RIB
7	2	D2581	MOUNTING BRACKET
8	2	D3442-1	SHIM
9	2	D3825-041	RIB ASSY (BASKET END)
10	2	D3826-041	RIB/GUSSET ASSY
11	1	D3827-041	RIB ASSY (INBOARD)
12	2	D3833-1	MESH, BASE END FACE
13	1	D3832-1	MESH (BASE)

H	REVISED PARTS LIST AND ADDED "ITEM" COLUMN TO PARTS LIST (ZN D3-1); REVISED SECTIONS A-A, B-B AND C-C (ZN C6-3, C2-3 AND A6-3); REVISED DETAIL D (ZN B7-4); ADDED DETAIL E (ZN A6-4); ADDED SECTION F-F (ZN B2-4); ADDED DWG DETAILS FOR D2221-1/-5/-7 (SHEET 5); TOL REVISED TO 2 DEC PLACES (ZN D8-3 AND ZN B4-3); D3825-041 REPLACES D2221-3/D2377-3; D3826-041 REPLACES D2235-1/D2325; D3827-041 REPLACES D2221-1 ON INBOARD SIDE; ADDED D3832-1 AND D3833-1. REASON: SATISFY "LEAN MANUFACTURING" PROGRAM.	MB	08.09.18
G	MATERIAL FOR -1, -3, -5 & -7 WAS 0.060 WALL; TOLERANCE FOR 96.00 DIM WAS +/-0.01 AND 56.00 DIM WAS REF (ZN B5-2); 19.62 DIM WAS "HARD" DIMENSION IS NOW "REF" (ZN B4-2); NOTE 5 TRANSFERRED FROM SHT 1 TO SHT 2; SHT 2 MESH MATERIAL UPDATED; DRAWING TRANSFERRED TO "B" FORMAT	AJS	08.06.16
F	ADD SHIM UNDER HINGE; ADD HOLES FOR SPLIT LID BASKET	PH	05.06.07
E	CHANGE HINGE	CP	01.04.19
D	CHANGE LATCH	BW	96.06.21
C	SEPARATE BASKET AND LID	KH	95.11.21
REV.	DESCRIPTION	BY	DATE
DESIGN	BW	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN			
CHECKED		DRAWING NO.	REV. H
MFG. APPR.		D2221	SHEET 1 OF 5
APPROVED		TITLE	SCALE
DE APPR.		BASKET BASE ASSEMBLY (350)	NTS
DATE	08.09.18	COPYRIGHT © 1984 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS UNDERSTANDING THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON, WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

- NOTES:
- 1) MATERIAL: N/A
 - 2) FINISH: POWDER COAT GLOSS WHITE (4.3.5.2) PER DART QSI 005 4.3
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: N/A
 - 8) WEIGHT: 42.00 lbs APPROX
 - 9) MASK ALL HOLES PRIOR TO POWDER COATING

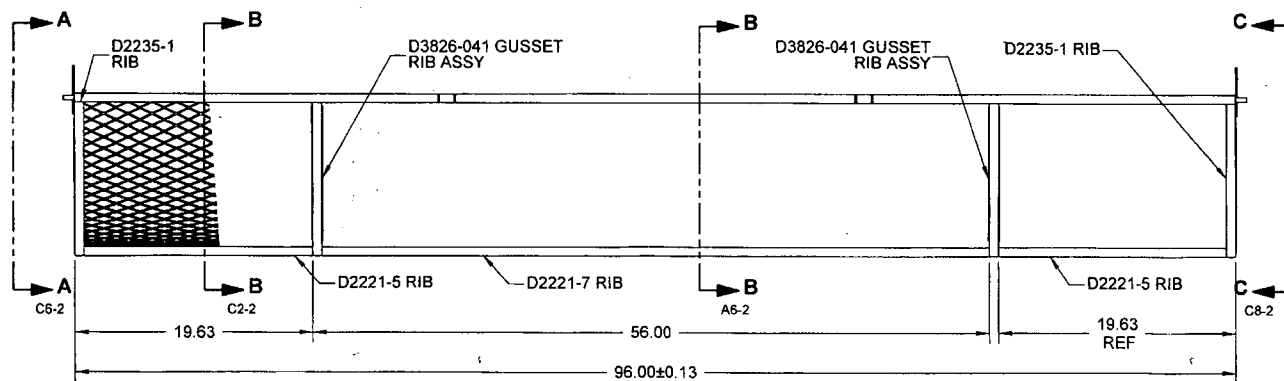
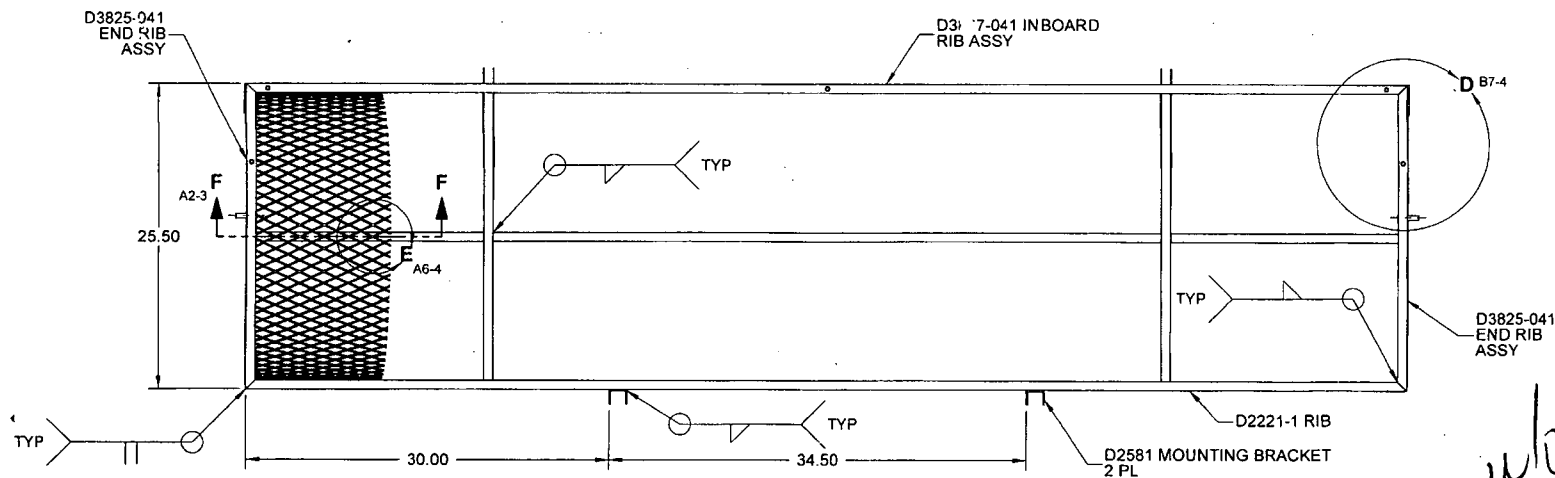
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D2221 BASKET BASE ASSEMBLY (350)
(MESH SHOWN LOCALLY FOR CLARITY)

RELEASED
06/11/18

DESIGN	B/W	DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO. D2221	REV. H
MFG. APPR.			SHEET 2 OF 5
APPROVED		TITLE	SCALE
DE APPR.		BASKET BASE ASSEMBLY (350)	NTS
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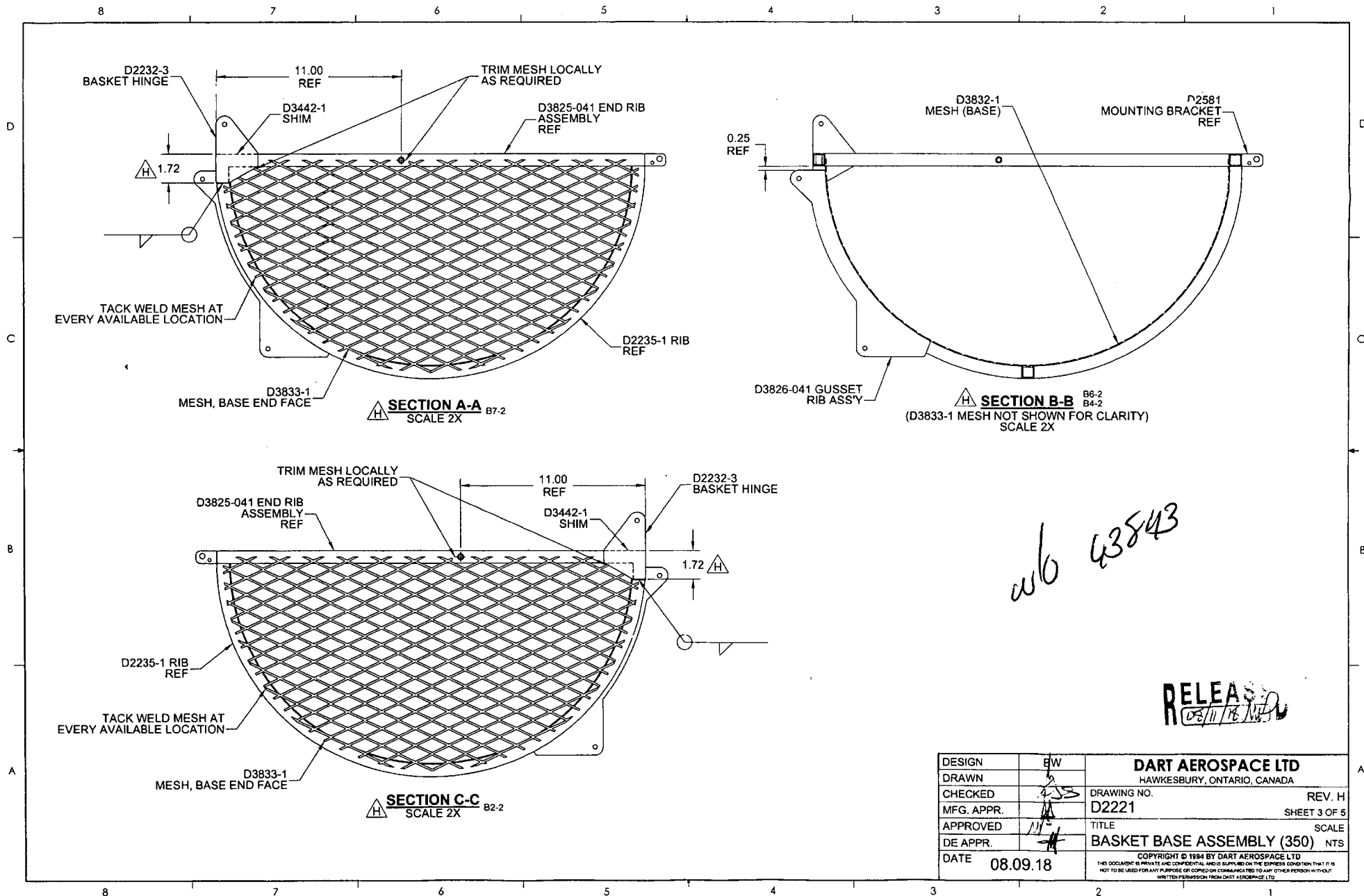
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DESIGN	BW	DART AEROSPACE LTD	
DRAWN	433	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO. D2221	REV. H
MFG. APPR.		TITLE	SCALE
APPROVED		BASKET BASE ASSEMBLY (350) NTS	
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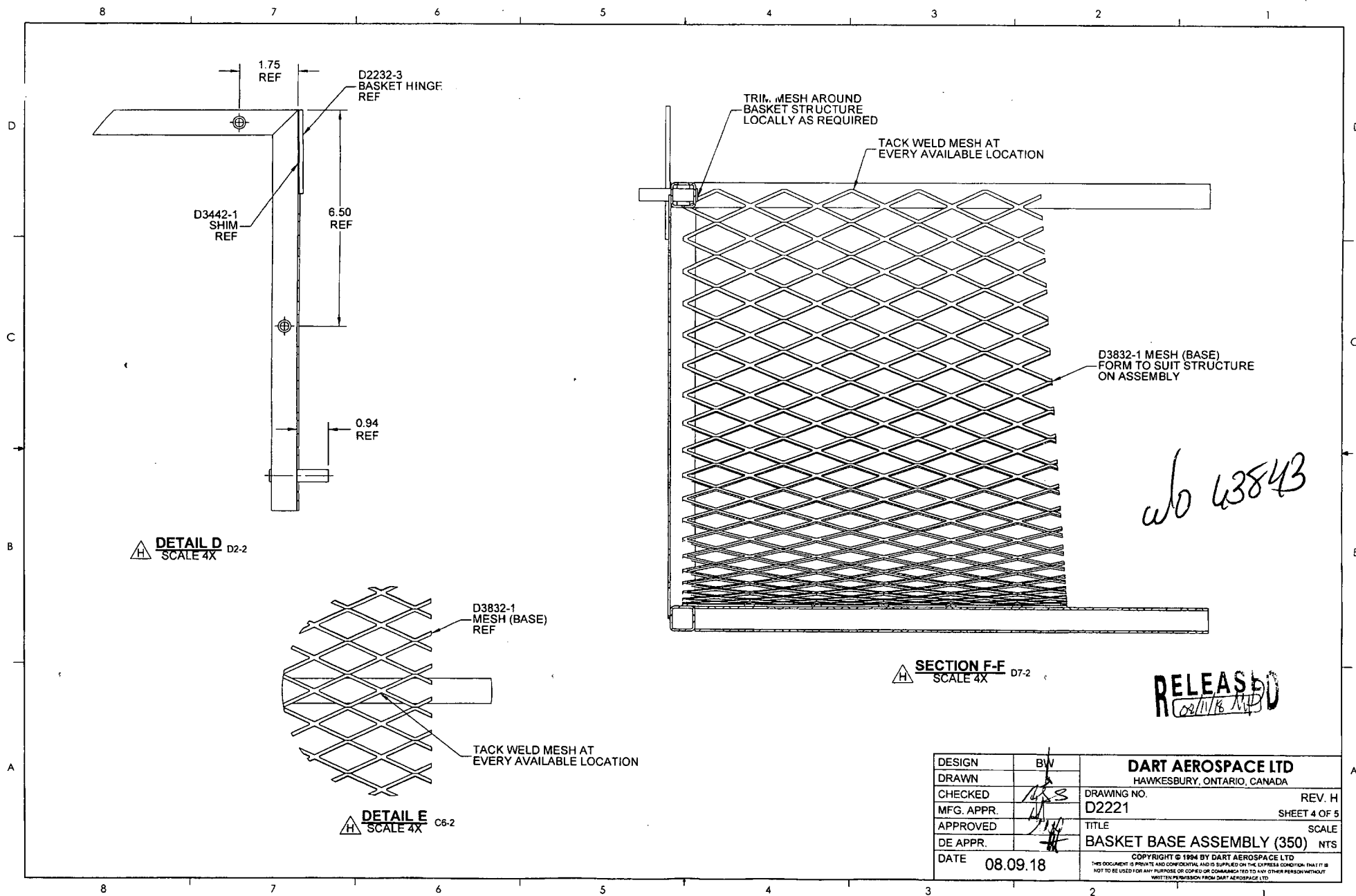
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CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. H
MFG. APPR.	<i>[Signature]</i>	D2221	SHEET 4 OF 5
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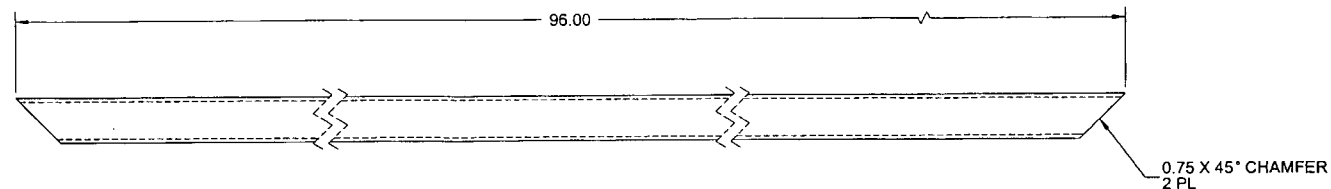
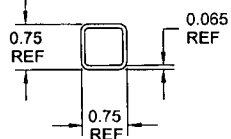
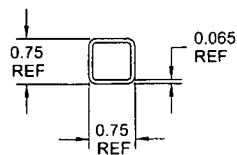
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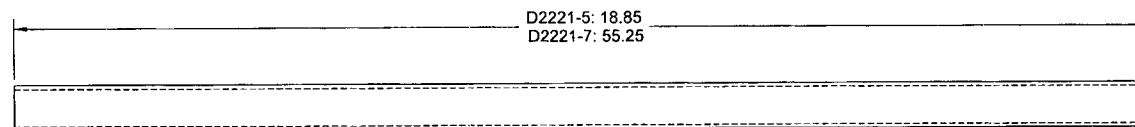
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D2221-1 RIB







D2221-5/-7 RIB

u/b 63843

RELEASED
CB/11/18/10

NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SQUARE TUBE, 0.75 X 0.75 X 0.065 WALL
REF. DART SPEC. M304TS0.750W0.065
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 8) WEIGHT: D2221-1 = 4.57 lbs; D2221-5 = 0.90 lbs; D2221-7 2.65 = lbs

DESIGN	BW	DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO. D2221	REV. H
MFG. APPR.		SHEET 5 OF 5	
APPROVED		TITLE	SCALE
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